

Date: Thursday, 11/09/2008 10:41:49 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CROSSBOLT SPACER
Job Number	: 41970		
Estimate Number	: 11010		
P.O. Number	:	Part Number	: D2649
This Issue	: 11/09/2008 S.O. No. :	Drawing Number	: D2649 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 41594	Material	:
Written By	:	Due Date	: 15/10/2008 Qty: 200 Um: Each
Checked & Approved By	: <u>JUL 08.9.11</u>		
Comment	: Est F 02.03.26 Added turning on Cobra NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T0375W058	6061-T6 RD Tube .375 x.058W
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200

Comment: Qty.: 0.2975 f(s)/Unit Total: 59.4930 f(s)
 6061-T6 Tube .375 x.058W

Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

Batch M109314 mmf 08/09/19

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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200

Comment: HARDINGE CNC LATHE SMALL

Machine as per folio F214 on cobra machine.

mmf 08/09/19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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200

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/09/19

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/09/21 (200)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Barkeley

DS 08/09/22 (200)

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/09/23

Job Completion



mmf 08-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

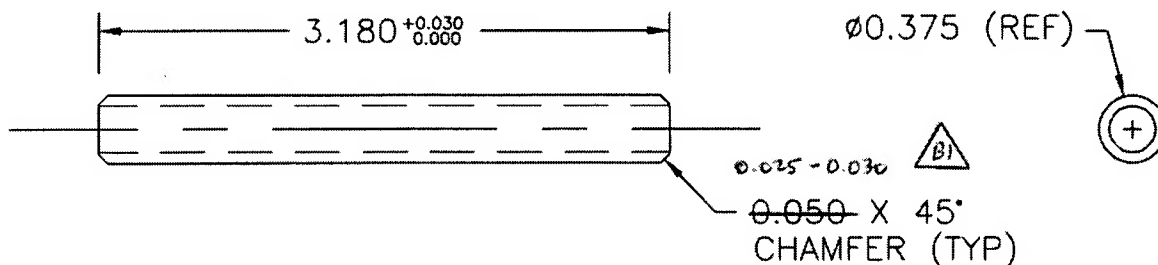
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	# <i>CP</i> 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *41910*